

Work Order ID 68388

Tuesday, April 12, 2011 1:51:15 PM



Page 1

Item ID:	D350-607-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Helix-Utility-Basket					
Start Date:	4/12/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/19/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-5	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								

100		DOCUMENT CONTROL	0.00						
DC		Memo	0.00						
Document Control		Photocopy bluefile & type labels per PPPD350-607-043 CHG005 PRINT DWG PAGE: 41/42 OF 162		Silvestro					11-5-5 (label only)
110		Pick Kit	0.00						
Packaging		Memo	0.00						JB 11/0504
Packaging									
120		Small Fab	0.00						
Small Fab		Memo	0.00						
Small Fab		Assemble as per Dwg D350-607 Seal Support Gusset with Sikaflex -291 Batch: M116 945 Exp Date: 12/01/15							11/05/05 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68388

Tuesday, April 12, 2011 1:51:15 PM



Page 2

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulostol

⑩

Pupps

①

Sulostol

⑩

W/O:		WORK ORDER CHANGES					
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Work Order ID 68388

Tuesday, April 12, 2011 1:51:15 PM



Page 3

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-043

Location: BK

REV 4

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

mf

11-05-05

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, April 12, 2011 1:51:21 PM

Page 1

Work Order ID: 68388

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket






Start Date: 4/12/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-3 		Manufactured	No			110	Each	0.0000	2	2 ✓			
Dart Logo label													
D350-607-241 		Manufactured	No			140	Each	2.0000	1	1			
Basket Clamp Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG022		2							
				67712		2				67712			
D2022-101 		Manufactured	No			110	Each	29.0000	5	5 ✓			
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		29							
				66939		29				66939			
D2221 		Manufactured	No			110	Each	0.0000	1	1			
350 Basket Base													
D2258-200 		Manufactured	No			110	Each	5.0000	1	1 ✓			
Placard 2001b													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST505		5							
				64284		5				64284			

B68389 (N)

115050 JB L
67712
5 ✓
JB L
66939
1
EP 11/05/05
1
JB 11/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, April 12, 2011 1:51:22 PM

Page 2

Work Order ID: 68388

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 4/12/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2332-041

Manufactured No

110 Each

8.0000

1

1 ✓



Lid Prop Assembly 6.69" long



JB

Location

Loc Qty

Loc Code

ST512

8

62950

4

66233

4

66233

D2530

Manufactured No

110 Each

12.0000

1

1 ✓



Handle Weldment

Location

Loc Qty

Loc Code

ST506

12

66171

4

66563

8

66563

D2535

Manufactured No

110 Each

63.0000

2

2 ✓



Spring

Location

Loc Qty

Loc Code

ST504

63

64280

9

66764

54

66764

D2537

Manufactured No

110 Each

56.0000

2

2 ✓



Bushing

Location

Loc Qty

Loc Code

ST504

56

65077

14

66972

42

65077

JB 11/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, April 12, 2011 1:51:22 PM

Work Order ID: 68388

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 4/12/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 110 Each 692.0000 2 2 ✓



Bumper

Location

Loc Qty

Loc Code

ST504

692

46064

692

46064

D2989-041 Manufactured No



Basket Lid Assembly

110 Each 0.0000 1

B68391 (12)

EPB 11/05/05

D2989-043 Manufactured No



Basket Lid Assembly

110 Each 0.0000 1

B68392 (12)

EPB 11/05/05

AN3-16A Purchased No



Bolt

110 Each 67.0000 2

EPB 11/05/05

Location

Loc Qty

Loc Code

ST352

67

114752

17

116419

50

114752

AN4-13A Purchased No



Bolt

110 Each 481.0000 2

EPB 11/05/05

Location

Loc Qty

Loc Code

ST357

481

117313

481

117313

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, April 12, 2011 1:51:23 PM

Page 4

Work Order ID: 68388

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 4/12/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-22A Purchased No

110 Each

264.0000

7

7

✓



Bolt

Location

Loc Qty

Loc Code

ST359

264

114523

14

114784

100

116419

50

117313

100

114523 X 6

114784 X 1

AN5-17A Purchased No

110 Each

100.0000

4

4

✓



Bolt

Location

Loc Qty

Loc Code

ST339

100

116590

70

117313

30

116590

MS20600-AD4W3 Purchased No

110 Each

913.0000

2

2

✓



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

492

111636

492

WA018

421

107939

421

111636

AN960JD416 NAS1149D0463J Purchased No

110 Each

0.0000

14

14

✓



Washer

117291

JB 11/05/04

Tuesday, April 12, 2011 1:51:23 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 68388

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 4/12/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased

No

110

Each

5.0000

2



Washer

Location

Loc Qty

Loc Code

FP-B

5

110153

5

AN960JD516 NAS1149D0563J Purchased

No

110

Each

0.0000

4



Washer

AN960JD8 NAS1149DN832J Purchased

No

110

Each

0.0000

2



Washer

NAS1515H4 Purchased

No

110

Each

97.0000

2



Washer

Location

Loc Qty

Loc Code

ST277

97

111525

47

116169

50

AN970-4 Purchased

No

110

Each

115.0000

4



Washer

Location

Loc Qty

Loc Code

ST344

14

115936

14

ST349

101

116900

51

117317

50

2 ✓ m11/4103
114109 JB

4 ✓
117291 JB

2 ✓
117316 JB

2 ✓
116169 JB

4 ✓
JB 11/05/04

116900

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, April 12, 2011 1:51:23 PM

Work Order ID: 68388

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 4/12/2011

Required Date: 4/19/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,910.000

2

2



Nut



✓ JB

Location

Loc Qty

Loc Code

ST300

1910

116391

336

116540

800

116549

774

116540

MS21042L4

Purchased

No

110

Each

2,704.000

9

9



Nut



✓ JB

Location

Loc Qty

Loc Code

ST300

2704

116188

704

116823

2000

116823

MS21042L5

Purchased

No

110

Each

769.0000

4

4



Nut



✓ JB 11/05/04

Location

Loc Qty

Loc Code

ST300

769

115594

9

116105

500

116548

260

116105

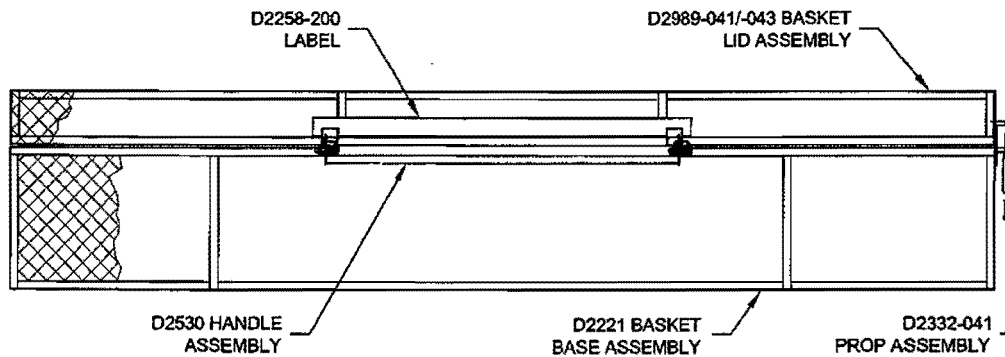
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

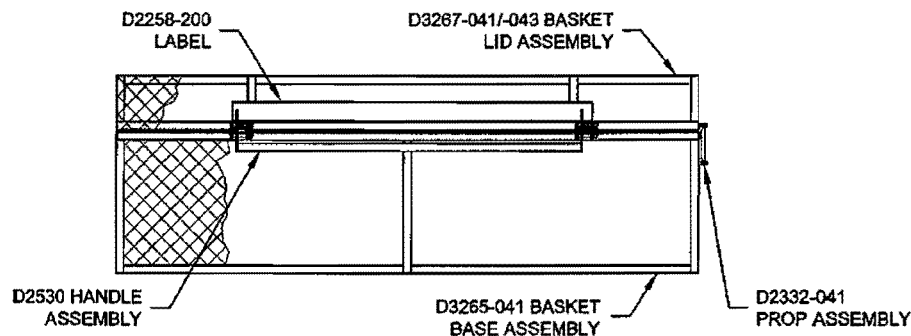
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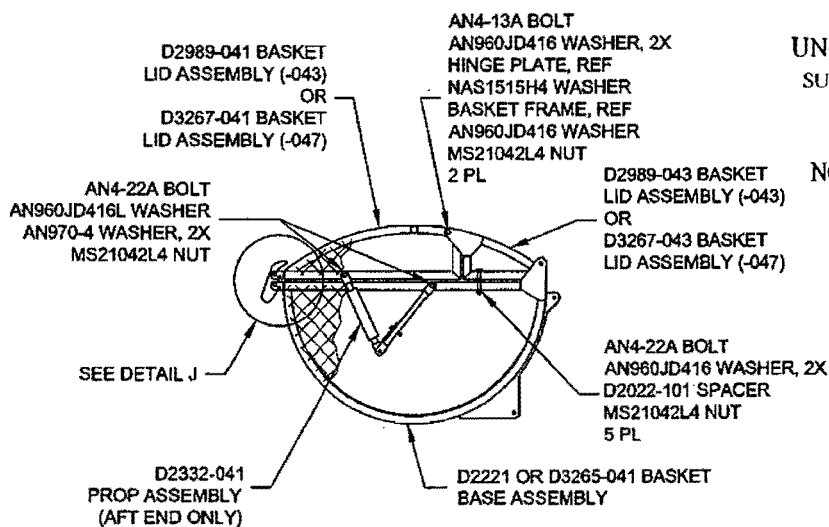
NOTE: Date & initial all entries



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48858

pln-08-4

Figure 6– Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

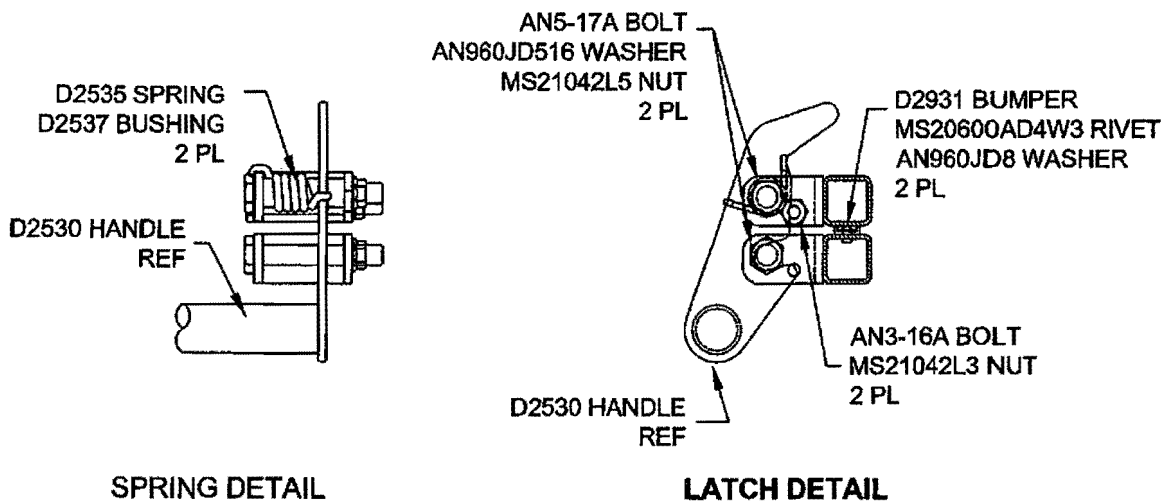
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

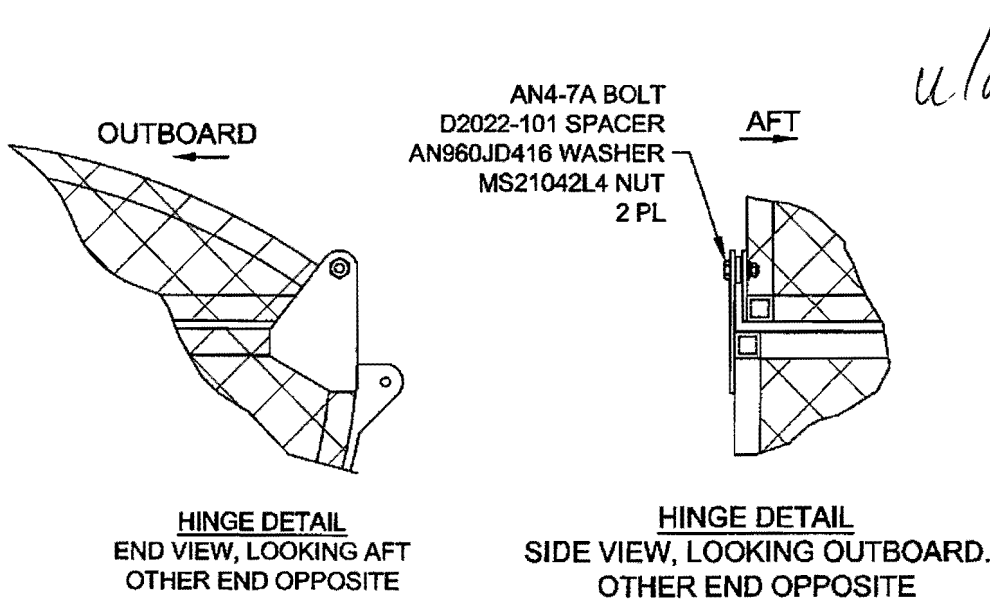
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**DETAIL J:
HANDLE WELDMENT**



**DETAIL H:
HINGE**

Figure 7 – Basket Replacement Parts

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Revision: **A**
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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